



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12841 ✓	42/50 ✓
2	Machined By		V.T.L Mic Shop	Drg No-LEC 9980
3	Pallet Die No.		13089 (4.0mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm ✓	Step of Tapper-12°
6	Inside Diameter	Drg. No.	590.12mm ✓	Step Length-18.5mm ✓
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-20.4mm Tapping Depth-18.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 14/09/24

1	As per programme no.		—
2	Gun Drilling Work Completed On		—
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter-60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.3mm ✓	outside (3-3)	Inner					
3	External Relief Depth		12mm ✓	8mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		14	09	24				

Inspected By (Sign) & Date

Ramanpreet Singh 14/09/24

Satish 14/9/24
Reviewed by (Engineer-CNC)

Manager-QA